Work Order	ID	106739
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\*106739\*

Page 1

September-11-1	3 11:35:12 A	M	<u> </u>	I \		)							-
Item ID: Revision ID:	D4030-043			Accept	*	<b>1900</b>	<u>040</u>	100	<b>)*</b> s	etup Sta	1/1	S1*	
Start Date:	9/11/13	Start Qty: 1.00	*1*			Cust Item	ID:				° ^ N	S2*	
Required Date: Reference:	: 9/11/13	<b>Req'd Qty:</b> 1.00	*1*			Customer:							
Approvals:	Process Pla	n: MLJ	Date: 13-09-16	Tooling:		D	ate:		R		art *N	R1*	
	QC:		Date:	<b>SPC (Y/N):</b>		D	ate:				<sup>op</sup> ≠. *N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	3	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr											
D4030	D												D/
, 100		Pick Kit		0.00					3 4				20 9-8
*100* Packaging Packaging		Мето		0.00					İX	<del></del>	13-	12-5	. 3~0
											;	DAS	•   •   •
110 ;		Assemble as per dwg		0.00							/ A	11	
*110* HandFinish Hand Finishing		Memo		0.00							<u> </u>	<u> </u>	I ČL Č
			W	0.00	SHP				•			•	:
120		QC5- Inspect part comp	leteness to step on W/O	0.00	1					•			
*120* QC Quality Control		Memo		0.00	2/6								

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Mort Ordo					DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Work Orde	r:				Rework		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	^				Scrap		Machining Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raitiv	·				Use-as-is	The	moforming	Finishing	4	re/Packaging	Other
NCR N	0.				Work Order Update	1110	Large Fab	Composite	1100,010	Supplier	1 5
			· · · · · · · ·			<b>'</b>			l		ا ا
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief En	g Descr	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		ļ									
Material							1				
Setup		ļ									
Other							1				
Process											
Supplier [											
Training										1	
Unapproved		<u></u>									
					FA	AULT CAT	EGORY				
Landir	ng Gear				General			_	-		-
	Bending				Bend	Grain			Ovalized		Pressure/Forced
. [	Centre N	ot Concei	ntric to	o/s	BOM/Route	Hardv	vare		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped Burrs					Instructions Incomplete/Unclear				issing	Wrong Stock Pulled
	Cuffs Contamination					Maintenance Pa			Part Moved		
	Heat Treat Countersink				Countersink	Misla	peled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-11-13	er ID 106739 3 11:35:12 AM		*106				Page 2	:		
Item ID: Revision ID:	D4030-043		Accept	*N900040	100	* s	Setup Star	i VI	S1*	1
Item Name:	Long Basket Assembly, Light Lid	(350)					Stop	' *N;	S2*	
Start Date: Required Date:	9/11/13 <b>Start Qty:</b> 1.0 <b>9</b> /11/13 <b>Req'd Qty:</b> 1.0	-		Cust Item ID: Customer:						
Reference:		-					<b>G</b> .			
Approvals:	Process Plan:	Date:	Tooling:	Date:		F	Run Star Stop	I <i>Л</i>	R1*	
	QC:	Date:	<b>SPC (Y/N):</b>	Date:			Stop	*N	R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID Tool #		Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
130	Identify as per dwg	& Stock Location:	0.00				1	1	<b>∽</b>	
*130* Packaging Packaging	Memo		0.00	109715	-		[3] B	46		
:	OCAL Final Income	ion Work Order Palance	0.00			in	6		•	
* <b>14</b> 0	QC21- Finai Inspec	ion - Work Order Release	0.00		(	A	fam.	13/12/0	9	
QC	Memo		0.00		_	1/ //			· ·	

Quality Control

MF 12-06.

										DQA:	Date:	
NCR: Y	es / N	0				WORK ORDER NON-	CONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	rr:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N						Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descrip	tion of work order update	Initial	Ac	tion	Sign &		
Cause	Dat	e   S	Step	Qty	10	Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling										:		
Operator												
Material												
Setup												
Other		- 1	1									

## **Landing Gear** General Bending Bend Ovalized Pressure/Forced Grain BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Part Incorrect Cracks Inspection Incomplete Weld Crushed/Crimped Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Mislabeled Heat Treat Countersink Positioned Wrong Misread Inspection Strip in Tube Cut Too Short Power Loss/Surge Other Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

**FAULT CATEGORY** 

Process
Supplier
Training
Unapproved

## Picklist Print

September-11-13 11:35:10 AM

Work Order ID:

106739

Parent Item:

D4030-043

Parent Item Name:

Long Basket Assembly, Light Lid (350)

**Start Date: 9/11/13** 

Required Date: 9/11/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC 10.04.20 verified by:EC

IPP Rev:B as per dwg revB DD

DD VERF:EC

IPP Rev:C added NAS1149F0332P & NAS1149C0432R 10.06.16

10.08.18 verified by:EC

IPP Rev:D as per dwg revC DD

1	10.08.18 verified b	y.EC											•
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 Handle Weldment		Manufactured	No			100	Each	12.0000	1	1	Blo	663	9
				Location		Loc Qty	Lo	oc Code					1
·				ST255		12							
					3407	3							
				105	5285	2							
				921	130	2							<b>8</b> 2
e .				980	072	5							D/
D2535		Manufactured	No			100	Each	144.0000	2	2			2( 9-8
Spring												<del></del>	
				<b>Location</b>		Loc Qty	<u>La</u>	oc Code					
:				ST011		144							
· §					0552	98				$\supset_{\mathcal{X}}$			_
					2576	46							* A <sub>*</sub>
D2537		Manufactured	No			100	Each	142.0000	2	2		_	/
Bushing		Manufactured									/3	-/)-(	Q
				<b>Location</b>		Loc Qty	<u>La</u>	oc Code			,		
. 8				ST008		38							
en e				102	2982	30							
				99(	011	8							
÷ .				ST011		104							i
*				100	0454	38				2x			
¥				103	3608	24				<del></del>			
				103	3861	40							
				984	426	2							

							•				DQA	:D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	<b>JANCE / UP</b>	DATE			•	-
							<del></del> ,				QA Closed	: D	ate:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Orac	٠					Rework	1		Skid-tube	Crosstube	1	Water Je	· 🗀	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor	$\vdash$	Quality
	•					Use-as-is	1		noforming	Finishing	4	re/Packaging		Other
NCR I	No.					Work Order Update		1	Large Fab	Composite		Supplie	_	
			1	,				L,			- -	ī		
Root					i	ption of work order update	1	Initial		tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	on	QC Inspector
Doc/Data	Ш													
Equip/Tooling	Щ		Ì											
Operator	Ш									•				
Material	Ш													
Setup	Ш													
Other	_									e .				
Process	Щ						ı							
Supplier	Щ		1				l							
Training	<u> </u>		ļ											
Unapproved			İ									<u> </u>		
		<del></del>				<del></del>	ΑUI	LT CATE	GORY			<del></del>		
Landi	ng (					General	_	7			7		_	1
		Bending			_	Bend	L_	Grain			Ovalized			Pressure/Forced
	L	Centre N	ot Conce	ntric to	O/S	BOM/Route		Hardwa	re		Over/Unde	r tolerance		Temperature/Cure
		Cracks			<u></u>	Broken/Damaged		4	on Incomplete		Part Incorre	ect	$\vdash$	Weld
		Crushed/	Crimped		_	Burrs		-	ions Incomplete/	Unclear	Part Lost/N	_		Wrong Stock Pulled
	<u></u>	Cuffs				Contamination	Maintenance				Part Moved			
		Heat Trea	at		L	Countersink	Mislabeled				Positioned Wrong			
	Inspection Strip in Tube Cut Too Short							Misread Power Loss/Surge Other					Other	
1	1	Rinnles in	Rend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	106739										
Parent Item:	D4030-043							Start	<b>Date:</b> 9/11/13	Required Date: 9/11/13	
Parent Item Name:	Long Basket Assem	ably, Light Lid (350)						Start	<b>Qty:</b> 1.00	Required Qty: 1.00	
D3913-041 Long Basket Base Asser	nby, 350	Manufactured	No			100	Each	2.0000	1-13/06	1737 (1) Block	10
				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code	,	,	,
				FP		1					
					102866	1					
				GA		1					
					103140	1					
D3915-041 Light Lid Assemby, Lon	o Basket	Manufactured	No			100	Each	0.0000	131044	12 (1x) Il istate	36
<b>D3917-3</b> Washer	5 - m	Manufactured	No			100	Each	235.0000	6	6 DAS 26	1
· · · · · · · · · · · · · · · · · · ·				Locatio	n	Loc Qty		Loc Code		26 9-89	
				ST072	_	235	į				
				0.0,2	100397	70					
					102913	4					
					103536	41					
•					104859	120	)			•	
D3953-3 Gas Spring Stud, Lid		Manufactured	No			100	Each	43.0000	2	2) R/OLES 70 DAS 26	
				Locatio	<u>n</u>	Loc Oty		Loc Code		9-89	
				GA		1					
					87592	1				<u>.</u>	
				ST076		42	2				
					102196	28					
1					88494	14					
<b>*D3953-7</b> Spring Spacer		Manufactured	No			100	Each	92.0000	2	3313-12-6	DAS 26 9-89
				Locatio	n	Loc Oty		Loc Code			9-89
				ST076	_	92	,				
				51070	100414	22			<del></del>		
					102928	24			-	<del>-</del> :	
					105465	45			D1	-	
					99148	1				- -	
			·							D 2	

									DQA:	Date:	
NCR: Ye	es / N	lo ;			WORK ORDER NON-	CONFO	RMANCE / U	PDATE	QA Closed:	Date:	
Work Order	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update	The	Skid-tube  Machining rmoforming  Large Fab	Crosstube Small Fab Finishing Composite	╡	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Description of work order update	Initial	Α	Action	Sign &		
Cause	Dat	:e	Step	Qty	or Non-conformance	Chief Er	ng Des	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling		- 1									
Operator											
Material		:					-				
Setup						İ					
Other											
Process											
Supplier											
Training											
Unapproved											
					į	<b>FAULT CA</b>	regory				

Landir	Landing Gear		General	_	_	 	
	Bending		Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S		BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks		Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped		Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs		Contamination		Maintenance	Part Moved	•
	Heat Treat		Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube		Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend		Drill Holes		Offset		
	Torque Waves in Extrusion		Drawing		Out of Calibration		
	Turning Sequence		Finish		Out of Sequence		
	Wave/Twist in Tube		Folio		Outside Dimensions		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	106739								
Parent Item:	D4030-043						Date: 9/11/13	Required Date: 9/11/13	
Parent Item Name:	Long Basket Assembly, Light Lid (350)					Start	<b>Qty:</b> 1.00	Required Qty: 1.00	ı
D3953-9 Gas Spring Washer	Manufactured	No		100	Each	76.0000	2	2	DAS 26
			Location	Loc Qty		Loc Code		,	
			ST076	76					
			102166	21					
			103615	46				<u> </u>	
e tra			94719	4				<u></u>	
			95127	5					DÁ
D3953-17	Manufactured	No		100	Each	22.0000	2	(2)X/X2Q(0)	26
Gas Spring Spacer								9,000,00	DA 26 9-8
			Location	Loc Qty		Loc Code			
			ST075	22					
			100353	22				516	
D3953-19	Manufactured	No		100	Each	15.0000	1	OB107601	DAS
Gas Spring Bracket							·	- DIO 1604	26 9-89
			<b>Location</b>	Loc Qty		Loc Code		/	, , , , , , , , , , , , , , , , , , ,
			ST077	15					1
			100341	15				<del></del>	
₹D3953-21	Manufactured	No		100	Each	15.0000	1	2 (1) /====================================	DAS
Gas Spring Bracket	Manufactured							/0507	26
			Location	Loc Qty		Loc Code	,		9-89
			ST077			<u>Loc Couc</u>			1
			100404	15 15				<del></del>	
1D3969-3		<b>N</b> I.	100404	100	Each	53.0000			DAS
6. F.	Manufactured	No		100	Each	33.0000	1	1 13-12-6	26
Gas Spring								11/440	DAS - 26 9-89
			<b>Location</b>	Loc Oty		Loc Code			
			ST262	53			<del></del>		
			100611	36			<u>/                                    </u>	····	
			99623	17					

NCR:	<b>Yes</b>	/ No				WORK ORDER NON-O	OI	AFOKI	MANCE / UPI	DATE			
											QA Closed:	Date	2:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	Part No. Scrap Machining Small Fab Use-as-is Thermoforming Finishing NCR No. Work Order Update Large Fab Composite									Finishing	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	tion of work order update	П	Initial	Act	ion	Sign &	<u> </u>	
Cause		Date	Step	Qty		or Non-conformance		nief Eng		ription	Date	Verification	QC Inspector
Doc/Data					-		$\vdash$						1
Equip/Tooling												<u> </u>	
Operator													
Material													
Setup											Ī	1	
Other													
Process			1				١						
Supplier	Ш		į				l						
Training													
Unapproved			<u> </u>										
							AUL	T CATE	GORY				
Landi	ng (	1				General		7			1	_	_
Ì		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to (	o/s	BOM/Route	L	Hardwa			Over/Under	<b>⊢</b>	Temperature/Cure
	Cracks Broken/Damaged							4 '	ion Incomplete	<u> </u>	Part Incorre	<b> </b>	Weld
	Crushed/Crimped Burrs							4	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Contamination						<b>—</b>	Mainte			Part Moved		
	_	Heat Trea			<u> </u>	Countersink	-	Mislabe		<u> </u>	Positioned \		<b>-</b>
	$\vdash$	Inspectio		Tube	<u> </u>	Cut Too Short	$\vdash$	Misread	i		Power Loss/	'Surge	Other
)						Drill Holes	Offset Out of Calibration						
						Drawing	Out of Calibration Out of Sequence						
1	1	Turning S	equence		Į.	Finish	ı	Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	106739					··· -··				
Parent Item:	D4030-043						Start I	Date: 9/11/13	Required	d Date: 9/11/13
Parent Item Name:	Long Basket Assembly, Light Lid (35	50)					Start	<b>Qty:</b> 1.00	Require	ed Qty: 1.00
AN3-14A Bolt	Purchased	No			100	Each	131.0000	4	4	DAS 26
			Location	<u>1</u>	Loc Qty		Loc Code			9-89
			ST351		30					
				m125709	30					
1 4			ST511		100				<del>,      </del>	
1				m126192	100			<u> 4</u> x	<b>(</b>	
			ST512		1					
				123759	1				<del></del>	
AN3-20A	Purchased	No			100	Each	88.0000	2	2	DAS
Bolt										26 9-89
			Location	<u>n</u>	Loc Qty		Loc Code			300
			ST513		88					
				117441	88				<del>\</del>	DAS
AN4-12	Purchased	No		<del></del>	100	Each	131.0000	3	3	DAS 26 9-8
Bolt									The second secon	9-8
			Location	<u>n</u>	Loc Qty		Loc Code			
3 1 1			ST356		131					
				124805	5					
				m125709	50					
in the state of th				m126193	76				<u>}</u>	
AN5 17A	Purchased	No			100	Each	417.0000	2	2 3-1	3-6
Bolt										
į v			Location	<u>n</u>	Loc Oty		Loc Code			*
*			GA		36					
				117872	36					
			ST337		4					
				124215	2					
				124805	2					
			st503		227			<del></del>		
<b>18</b>				m126176	227			9	<b>L</b>	
			ST514		150					
				125388	150					

NCR:	Yes	/	No
11011.	103	,	110

										ſ	QA:	Date	e:
NCR: Y	'es	/ No				WORK ORDER NON-C	CON	<b>VFORI</b>	MANCE / UPDATE		•		
										QA Clo	sed:	Date	2:
Vork Orde	r:					DISPOSITION			AGAINST (	DEPARTM	IENT/	PROCESS	
Part N	-					Rework Scrap Use-as-is		1	Skid-tube Crosstube  Machining Small Fab  noforming Finishing			Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo.		· .		<del></del>	Work Order Update		mem	Large Fab Composite		./3101	Supplier	
Root	Ī				Descri	iption of work order update	I	nitial	Action	Sign	&		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	Dat	te	Verification	QC Inspector
oc/Data								·				•	
quip/Tooling													
perator													
laterial													
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rocess							1						1
upplier							l						
raining													
napproved							<u> </u>						
						F	AUL	T CATE	GORY				
Landi	ng G	ear				General			<u> </u>			_	
		Bending				Bend		Grain		Ovalize	ed		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re	Over/L	Inder	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete	Part In	correc	t _	Weld
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/Unclear	Part Lo	st/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	Part M	oved		_
		Heat Trea	t			Countersink		Mislabe	led	Positio	ned W	/rong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i [	Power	Loss/S	Surge	Other
		Ripples in	Bend			Drill Holes		Offset	_				
		Torque W	aves in E	xtrusio	n [	Drawing		Out of 0	Calibration				
		Turning Se	equence			Finish		Out of S	Sequence				
		Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions				

## Picklist Print

Page 5

September-11-13	11:35:11 AM								<b>3</b> ;
Work Order ID:	106739								i
Parent Item:	D4030-043					Start I	Date: 9/11/13	3 Req	uired Date: 9/11/13
Parent Item Name:	Long Basket Assembly, Light Lid (350	)				Start	<b>Qty:</b> 1.00	Red	quired Qty: 1.00
AN5-21A Bolt	Purchased	No		100	Each	72.0000	2	2	DAS 26 9-89
		<u>I</u>	ocation	Loc Otv		Loc Code			
		S	T337	73	2				
			114714	:	5				
			124215	1				$\partial x$ .	DAS
			M126175	5	0				26
AN310-4 Nut	Purchased	No		100	Each	102.0000	3	3	9-89
		Ī	_ocation	Loc Qty		Loc Code			
		5	ST342	10	2				
1			112969	:	2				1
*			122800	:	2			<del></del>	
			M125716	4.	2				
			M125752		6				
			M126400	5	0			<u> 3</u>	
AN310C4	Purchased	No		100	Each	140.0000	2	$^{2}/^{2}$	12-6.
Nut		<u>]</u>	<u>Location</u>	Loc Qty		Loc Code			DA 26 9-8
			ST342	14					20 0.8
8			122993	3					

50 50

123831 126192 M125952

											DQA:	Date:	
NCR: Y	es/	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE			
								_			QA Closed:	Date:	
Work Orde	à.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	- No		,			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						<del></del> ,	AUL	LT CATE	GORY		·		
Landir		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped at		)/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instruct Mainte Mislabe	on Incomplete ions Incomplete/I nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes						Misread Power Loss/Surge Other Offset					Other	

Out of Calibration Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	106739										
Parent Item:	D4030-043							ate: 9/11/13		Required Date: 9/1	
Parent Item Name:	Long Basket Assembly, Light Lid (3	50)					Start (	Qty: 1.00		Required Qty: 1.0	
M\$21042L3_ Nut	Purchased	No			100	Each	6,501.0000	6	6		DAS 26
and the second s			Location	<u>1</u>	Loc Qty		Loc Code				9-8
			FP001		3						
				122141	3						
			GA		18						
				122452	18						
			ST314		325						
				111668	1						
	<b>V</b>			117885	32						
				119017	55						
				119075	138						
				123265	43			-			
1 <b>5</b> .				M126036	56						
•			ST506		1304						
				123900	905						
				124291	399						
			ST510a		4851						
; <u>\$</u> ;				M126275	851				١.		
2.94				M126333	4000				21		240
MS21042L5 Nut	Purchased	No			100	Each	1,095.0000	4	4/:	3-12-5.	DAS 26 9-89
			Location	<u>n</u>	Loc Qty		Loc Code				
\			ST314		114						
				125654	114						
			ST506		1						
				123900	1						
			st507		980						
. :			31307	125535	980						

NCR:	Yes	/	No
INCIN.	163	,	110

DQA: \_\_\_\_\_Date: \_\_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-	CONF	ORN	MANCE / UP	PDATE					
										(	QA Closed:	Da	te:	
Work Order	·:				DISPOSITION				AGAINST I	DEP	ARTMENT	PROCESS		
					Rework	7 <b>1</b>		Skid-tube	Crosstube			Water Jet		Engineering
Part No	o				Scrap	] [	ľ	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is	]   1		noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	0				Work Order Update	]		Large Fab	Composite			Supplier		
Root				Descri	ption of work order update	Init	tial	A	ction	T	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Chie	f Eng	Desc	cription		Date	Verificatio	n	QC Inspector
oc/Data	4													
quip/Tooling	_	1						l		- 1				
perator										1				
/Jaterial	_													
etup	_													
Other														
rocess													ļ	
upplier		1								- 1			ŀ	
raining	-												1	
Inapproved		<u> </u>				AULT	CATE	CORY				<del></del>		
Landin	g Geor				General	AULI	CATE	JUNT						
Earluin	Bending			Г	Bend	Пе	rain		F		Ovalized			Pressure/Forced
-	Centre No	ot Conce	ntric to (	<sub>2/5</sub>	BOM/Route	-	ardwa	re		-	Over/Under	tolerance	Н	Temperature/Cure
-	Cracks	000000		,,  -	Broken/Damaged	$\vdash$		ion Incomplete			Part Incorrec		H	Weld
1	Crushed/	Crimped			Burrs	$\mathbf{H}$		ions Incomplete,	/Unclear	-	Part Lost/Mi		Н	Wrong Stock Pulled
	Cuffs	<b>,</b>		<u> </u>	Contamination	-		enance	,	_	Part Moved	226		Title of the contract of the c
ŀ	Heat Trea	at			Countersink	$\boldsymbol{\vdash}$	lislabe			-	Positioned V	<b>Vrong</b>		
	Inspectio		Tube		Cut Too Short	<b>-</b>	lisreac			_	Power Loss/	=		Other
	Ripples ir				Drill Holes	-	ffset		L	L		5	ш	
F	Torque V		extrusion	n	Drawing	По	ut of (	Calibration		-				
	Turning S	equence			Finish	По	ut of S	Sequence		-	-			
Ī	Wave/Tw	vist in Tul	эe		Folio	По	utside	Dimensions		_				7

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:	106739										
Parent Item:	D4030-043						Start D	ate: 9/11/13		Required Date: 9/11/	/13
Parent Item Name:	Long Basket Assembly, Light Lid (350)						Start (	<b>Qty:</b> 1.00		Required Qty: 1.00	
MS24665-151 Cotter Pin	Purchased	No			100	Each	199.0000	3	3		26 9-89
			Location		Loc Qty		Loc Code				
•			GA		28						
				17566	28						
;			ST323		171						
* <del>}*</del>				122802	20						
				124859	4						
<u> </u>				125646	147			3	<u> </u>		DAS
MS24665-300 COTTER PIN	Purchased	No			100	Each	159.0000	2	2		26 9-89
COTTERTIN			Location		Loc Qty		Loc Code				
			GA		37		<u>Loc Couc</u>				•
			GA	118234	37						
			CT200	110234							
			ST299	104555	122						
				124555	122		2 100 0000		لأ		DAS
NAS 1149F0432P WASHER	Purchased	No			100	Each	2,180.0000	6	6		26 9-89
			Location		Loc Qty		Loc Code				
And the second s			ST295		180						
] •				122151	2						
				123522	4						
				123900	6			<del></del>			
				124580	13						
				124859	15				····		
				125268	140						
i i			ST510a		2000				<del>V</del>		
4.				M126221	2000				<u>X</u> _		DAS
NAS1149F0563P Washer	Purchased	No			100	Each	602.0000	4	4	13-12-5	26 9-89-
			Location		Loc Oty		Loc Code				7 00
			ST295		602			_			
			31273	121350	602			~XX			
				121330	002						

		!										DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					
												QA Closed:	D	ate:	
Work Ord	or:					DISPOSITION				AGAINST D	E	PARTMENT,	PROCESS		
WOIK OIG	٠		· <del></del>			Rework	7		Skid-tube	Crosstube	_		Water Je	· [	Engineering
Part I	No					Scrap	1		Machining	Small Fab	_	Pro	d. Eng. Coor		Quality
1 0.10						Use-as-is	-		noforming	Finishing		l	e/Packaging	_	Other
NCR I	No.					Work Order Update	┧ ˈ		Large Fab	Composite		1100,000	Supplie	_	
	•	· · · · · · · · · · · · · · · · · · ·				' <u>L</u>	د.	Į	·						ب ب
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data												,			
Equip/Tooling			İ						1						
Operator	Ш					9									
Material							ļ								} 
Setup							١								
Other			:												
Process									1						
Supplier															
Training										·					
Unapproved				l											
						F	AUI	LT CATE	GORY						<u>.</u>
Landi					_	General	_	7		_		1		_	1
		Bending				Bend	_	Grain		L		Ovalized		_	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire	L		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	L	-i '	ion Incomplete	Ļ		Part Incorred			Weld
		Crushed/	Crimped		ļ	Burrs	L	-	tions Incomplete/	'Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination	$\perp$	Mainte		L	_	Part Moved			
		Heat Tre	at			Countersink		Mislabe	eled			Positioned V	/rong		
1	1	Inspectio	n Strip in	Tube	1	Cut Too Short	1	Misread	<u>t</u>	j		Power Loss/:	Surge	1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: Parent Item:	106739 D4030-043						Start D	ate: 9/11/13		Required Date: 9/11/13	
Parent Item Name:	Long Basket Assembly, Light Lid (350)							Qty: 1.00		Required Qty: 1.00	DAS
NA\$1149F0332P Washer	Purchased	No			100	Each	9,038.0000	8	8		26 9-89
			Location		Loc Qty		Loc Code				
S. Commercial Commerci			GA		182						
				122063	182						
with the state of			ST294		158						
				122063	158						
			ST295		3						
				123352	3						
			st510		3695						
				123900	3695				) X		
			ST510a		5000						
				125646	5000						
NAS1149C0432R WASHER	Purchased	No			100	Each	7,368.0000	2	2	B-D-S.	\$
			Location		Loc Qty		Loc Code				
			ST292		2696						
				119124	6						
* 4				121255	32						
÷				121825	8						
				122441	77						
				m125807	2581						
			ST510a		4672				<b>\</b>		

4672

m126221

									DQA:	Date:	·
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
		<del></del>	<del>-</del>						QA Closed:	Date:	
Work Orde	eń:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	lo				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	] [
Root				Descri	otion of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	c	or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		ł									ļ
Material											
Setup											
Other											
Process					•						
Supplier											
Training		]									
Unapproved		<u> </u>									
	<u>.</u>				F/	<b>AULT CAT</b>	EGORY				
Landir	ng Gear				General			_	_		<b>-</b>
	Bending			<u> </u>	Bend	Grain		<u>L</u>	Ovalized		Pressure/Forced
	Centre N	ot Concei	ntric to	o/s	BOM/Route	Hardv	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insped	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
	Heat Tre	at			Countersink	Mislabeled Pos				Vrong	
	Inspection Strip in Tube Cut Too Short					Misread				Surge	Other
	Ripples in	n Bend			Drill Holes	Offset		_	_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

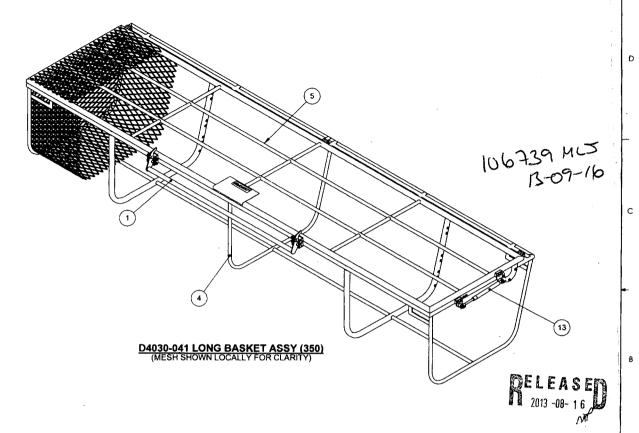
Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

ITEM	QTY -041	P/N	DESCRIPTION			
1	X	D4030-041	LONG BASKET ASSY (350)			
1 1	1	D2530	HANDLE WELDMENT			
2	2	D2535	SPRING			
1.3	2	D2535	BUSHING			
1 4	11	D3913-041	LONG BASKET BASE ASSY (350)			
1 5	1	D3913-041	LONG BASKET LID ASSY (350)			
16	6	D3914-041	WASHER			
1.7	2	D3917-3	GAS SPRING STUD. LID			
1 8	2	D3953-3	GAS SPRING STOD, LID			
9	2	D3953-7	GAS SPRING WASHER			
10	2	D3953-9 D3953-17	GAS SPRING WASHER			
111	1	D3953-17	GAS SPRING SPACER			
112	1	D3953-19	GAS SPRING BRACKET			
113	1	D3953-21 D3969-3	SPRING			
	4	AN3-14A	BOLT. MACHINE			
1.14		AN3-14A AN3-16A	BOLT, MACHINE			
15	3		BOLT, MACHINE			
16		AN4-12				
. 117	4	AN5-17A	BOLT, MACHINE NUT. PLAIN, CASTELLATED			
118	3	AN310C4	NUT, PLAIN, CASTELLATED			
119		AN310-4	NUT. SELF-LOCKING			
20	6	MS21042L3 MS21042L5	NUT, SELF-LOCKING			
21	2		COTTER PIN			
22						
23	3	MS24665-151	COTTER PIN WASHER			
. 24	2	NAS1149C0432R	WASHER			
25	6	NAS1149F0432P				
26	8	NAS1149F0332P	WASHER			
1 27	4	NAS1149F0563P	WASHER			



REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	JPH	10.03.16
В	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH_	10.04.06
С	OTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (03-3).	МВ	10.07.23
D	REFORMAT FOR CLARITY PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18

DESIGN	AJS	DART AEROSPACE LT	D
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	4
CHECKED	P	DRAWING NO.	REV. D
MFG. APPR.	1800	D4030 s	HEET 1 OF 4
APPROVED	rus	TITLE	SCALE
DE APPR.	<del>-</del> #	LONG BASKET ASSY (350)	NTS

DATE 13.07.18

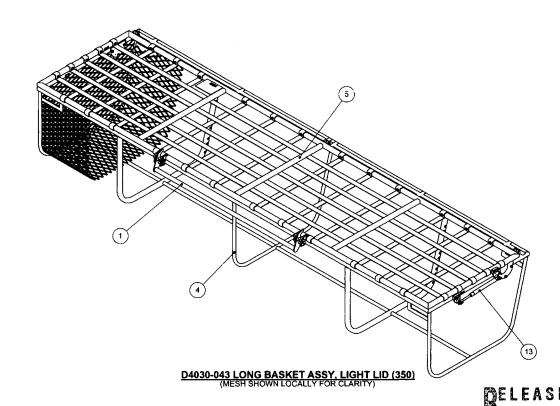
	OTES:	
1)	MATERIAL: N/A FINISH: NONE	
2)	FINISH: NONE	

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

D

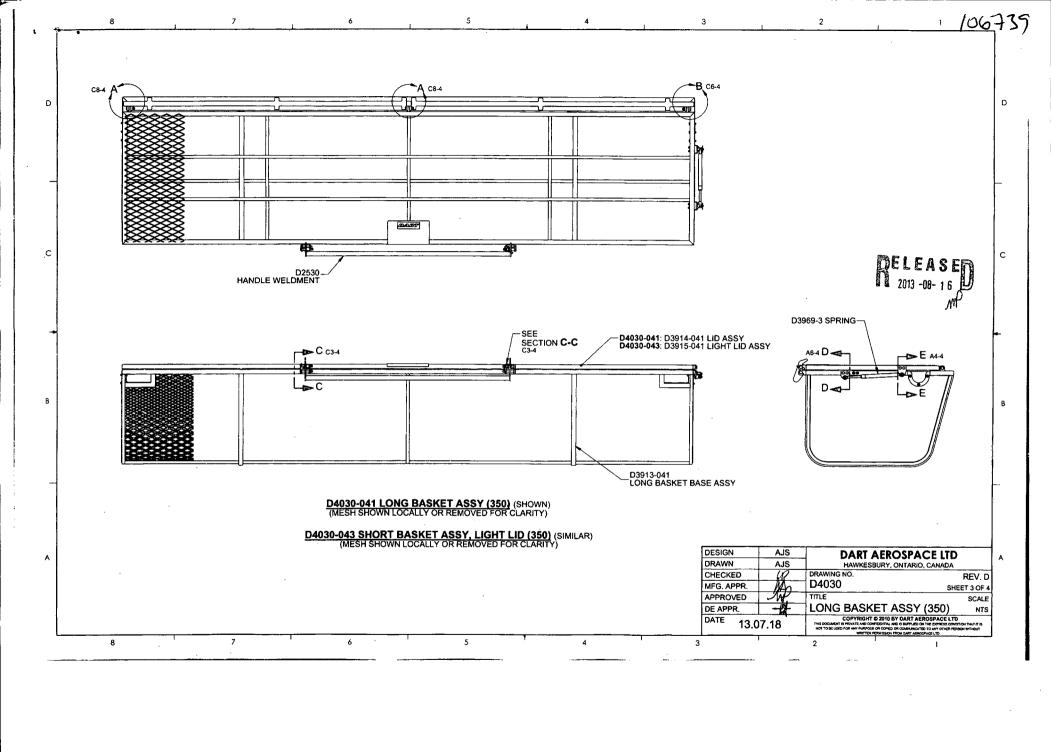
С

	ITEM	QTY -043	P/N	DESCRIPTION
		Х	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
				HANDLE WELDMENT
	1	1	D2530	
	2	2	D2535	SPRING
	3	2	D2537	BUSHING
Ď,	4	1	D3913-041	LONG BASKET BASE ASSY (350)
D C	5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
	6	6	D3917-3	WASHER
	7	2	D3953-3	GAS SPRING STUD, LID
	8	2	D3953-7	GAS SPRING SPACER
	9	2	D3953-9	GAS SPRING WASHER
	10	2	D3953-17	GAS SPRING SPACER
_	11	1	D3953-19	GAS SPRING BRACKET
	12	1	D3953-21	GAS SPRING BRACKET
	13	1	D3969-3	SPRING
	14	4	AN3-14A	BOLT
	15	2	AN3-20A	BOLT
	16	3	AN4-12	BOLT
	: 17	2	AN5-17A	BOLT
C	₹ 18	2	AN5-21A	BOLT
1	19	3	AN310-4	NUT, PLAIN, CASTELLATED
-	20	2:	AN310C4	NUT, PLAIN, CASTELLATED
	1 21	6	MS21042L3	NUT, SELF-LOCKING
	; 22	4	MS21042L5	NUT, SELF-LOCKING
	23	3 ;	MS24665-151	COTTER PIN
	24	2	MS24665-300	COTTER PIN
•	1 25	6	NAS1149F0432P	WASHER
i	. 26	4	NAS1149F0563P	WASHER
	27	8	NAS1149F0332P	WASHER
- 1	1 28	2	NAS1149C0432R	WASHER



DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN AJS DRAWN AJS DRAWING NO. CHECKED REV. D D4030 MFG. APPR. SHEET 2 OF 4 APPROVED SCALE DE APPR. DATE 13.07.18

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 57 lbs APPROX



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